










Date: Friday, 18/07/2008 1:10:13 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BATTERY LOCK ASSEMBLY
Job Number	: 40643		
Estimate Number	: 10900		
P.O. Number	:	Part Number	: D3393041
This Issue	: 18/07/2008 S.O. No. :	Drawing Number	: D3393 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 38322	Material	: N/A
Written By	:	Due Date	: 04/08/2008 Qty: 3 Um: Each
Checked & Approved By	: <u>JUL 08.7.18</u>		
Comment	: Est Rev:A New Issue 05-11-22 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D27287	Label	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
Pick:			
Qty Part Number		Description	Batch
1 D2728-7		Decal	22554
			8/12/15
2.0	D33731	Cam Lock	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
Pick:			
Qty Part Number		Description	Batch
1 D3373-1		Cam Lock	44105
			8/12/15
CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE			
3.0	516WC	SS Flat Washer 5/16	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)			
Pick:			
Qty Part Number		Description	Batch
2 5/16WC		SS Flat Washer	M10 9306
			8/12/15
4.0	D33931	Battery Lock Casing	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
Pick:			
Qty Part Number		Description	Batch
1 D3393-1		Battery Lock Casing	B 43123 ①
			1338333 ②
			8/12/15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:10:13 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 40643

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33933

Cam Lock Shaft



3X

Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3393-3

Cam Lock Shaft

B44108

8/12/17

SP

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5

3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal.

A/RN/A262 Locktite

M110005

SB 08/12/18

③

4-Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key

Key Numbers

1- 420A

5- _____

2- 420A

6- _____

3- 420A

7- _____

4- _____

8- _____

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack Weld lock shaft to flat cam of a Max 1/8" Long

Qty Part Number Description Batch

A/R N/A

SS Rod

M107051

17 8-12-18 x3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____

NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:10:14 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 40643

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

CP 08.12.18 *08.12.18 (X3)*

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Apply Crazy Glue to cap and press into Body

9567K21 Batch: *119102*

SB 08/12/19

10.0

9567K21

Polyethelene Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Polyethelene Cap

SB 08/12/19 (3)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/19 (X3)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *486*

8/12/19

3X
SD

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/19

Job Completion



MF 08-12-19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



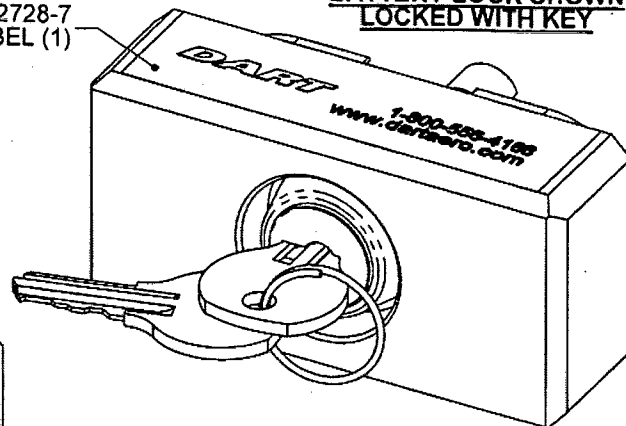
DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]

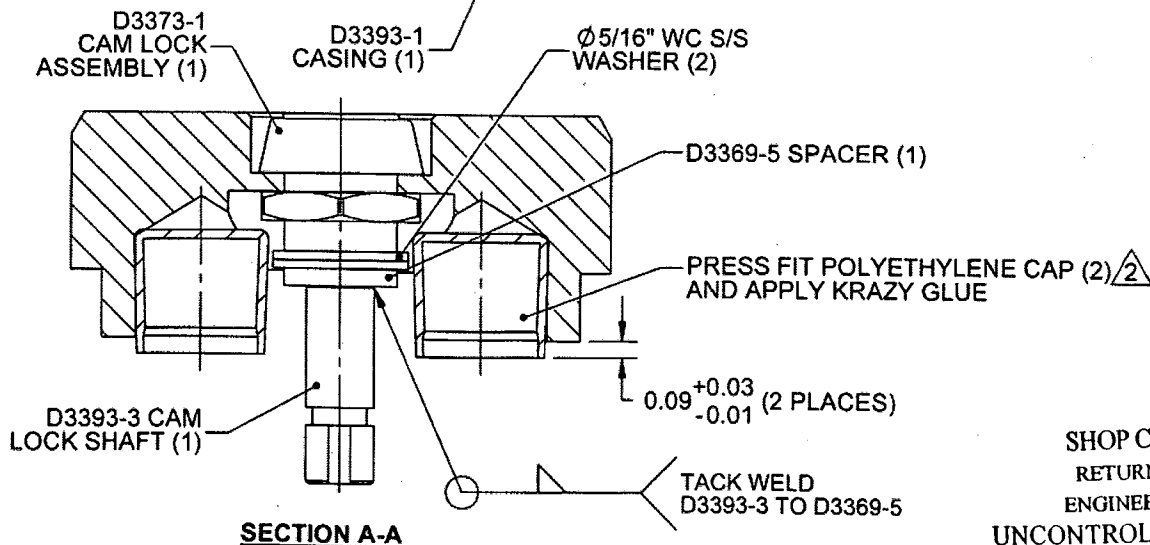
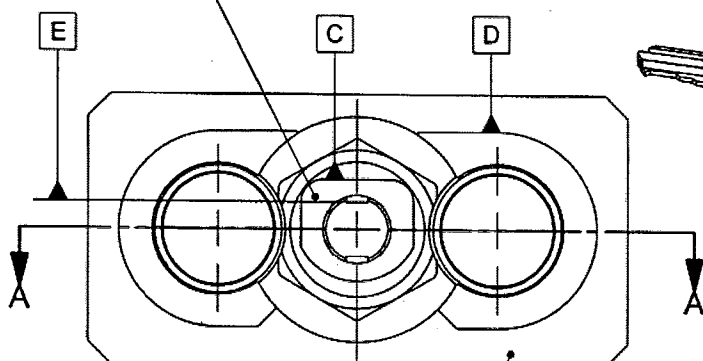
05/03/09

D2728-7
LABEL (1)

**BATTERY LOCK SHOWN
LOCKED WITH KEY**



POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWN



SECTION A-A

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

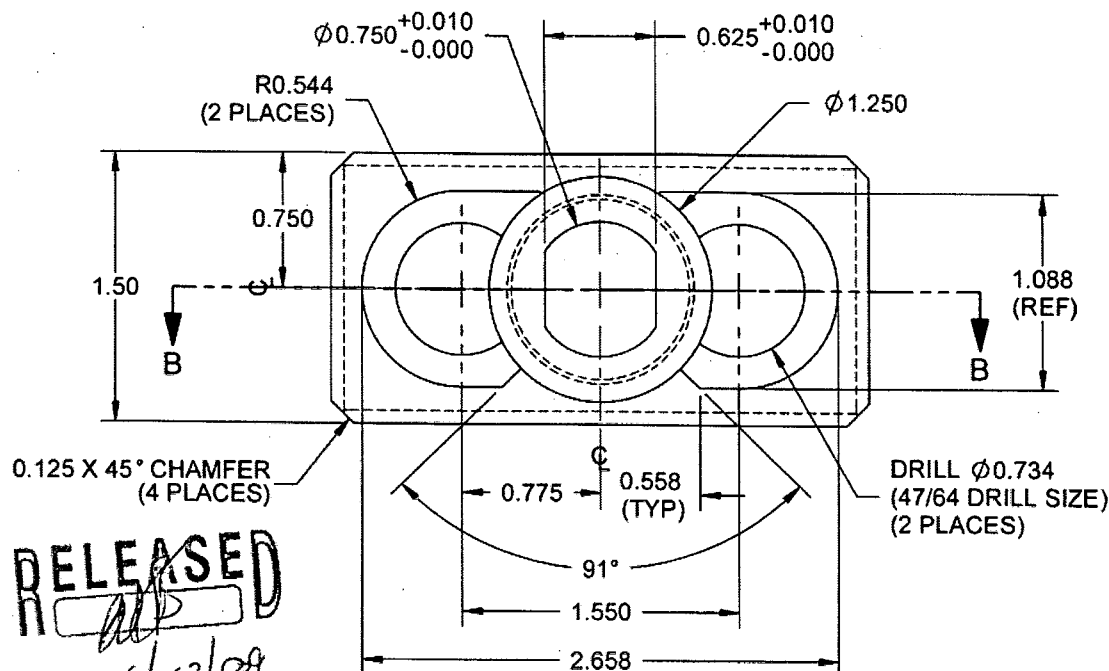
- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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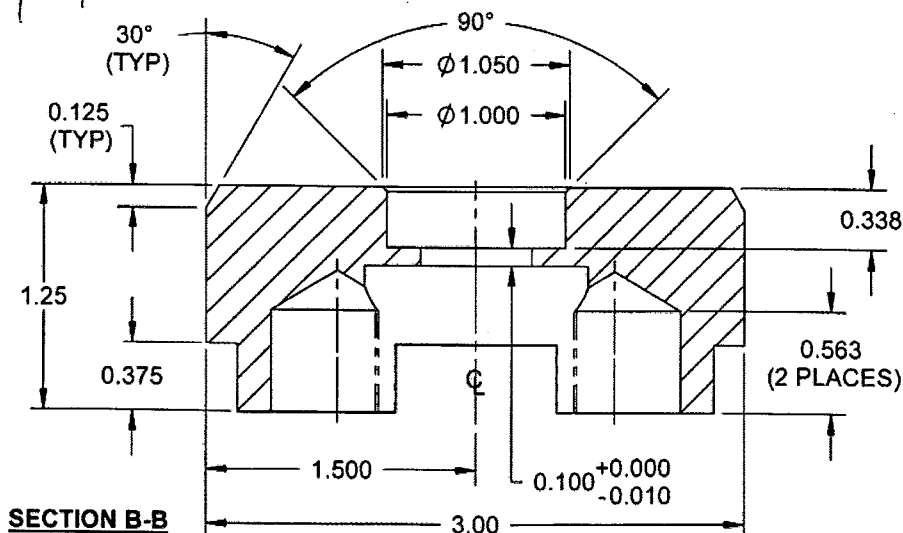
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CHECKED FF	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1



RELEASED
05/03/09



SECTION B-B

D3393-1 CASING

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

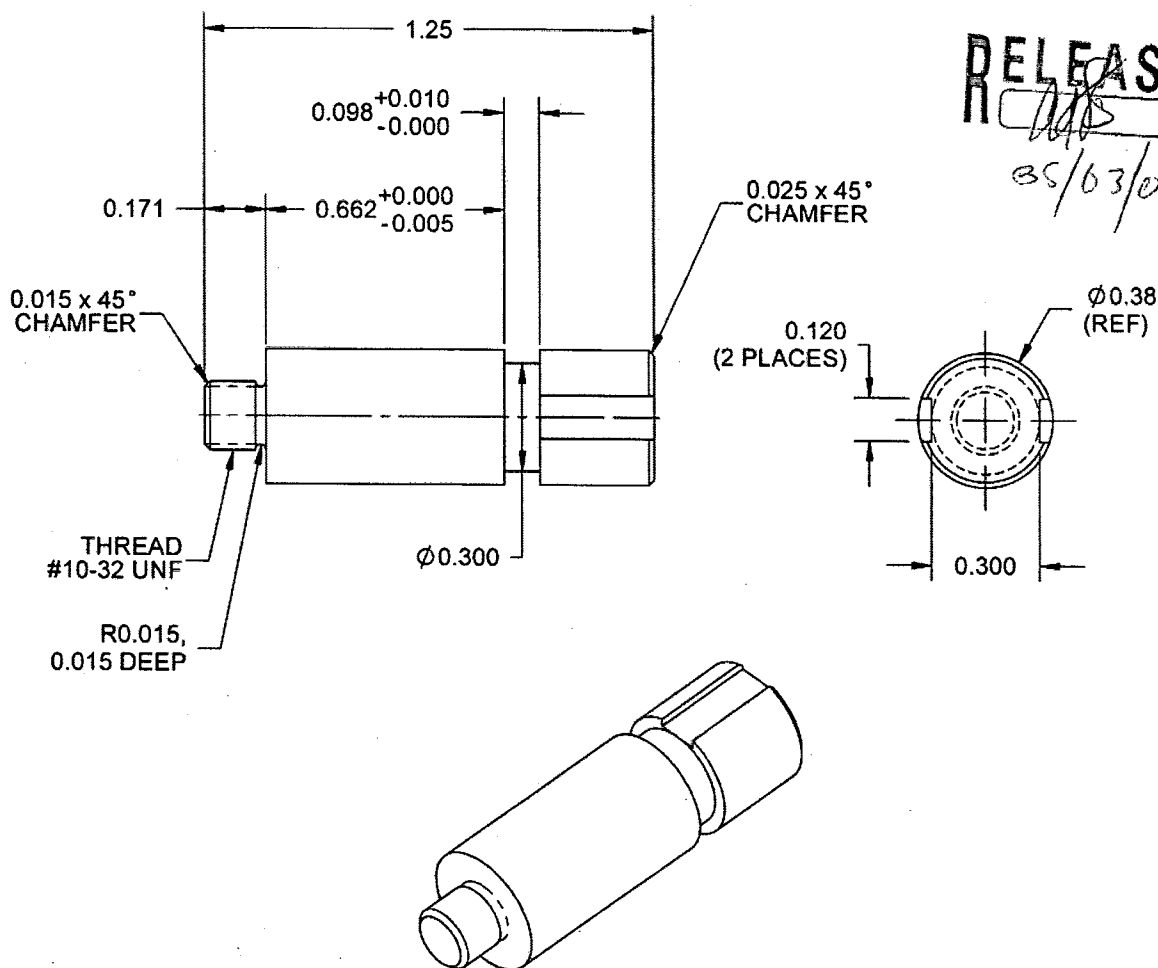
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CHECKED <i>13</i>	APPROVED <i>13</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1

**D3393-3 CAM LOCK SHAFT****NOTES:**

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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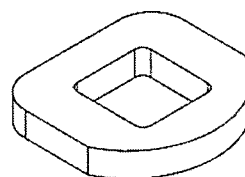
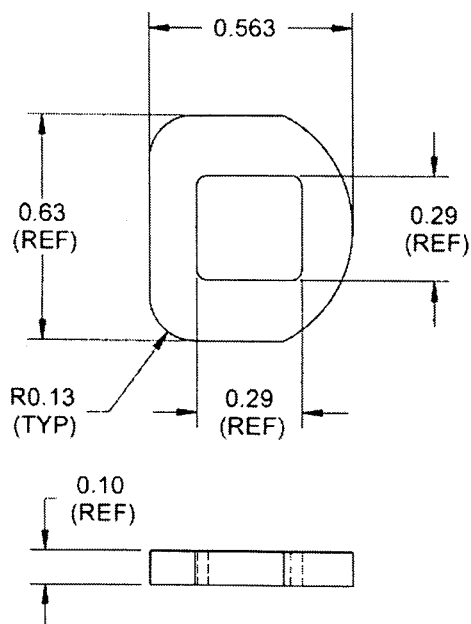
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



#40643

REFERENCE ONLY

-5
D3369 SPACER

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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